

Date: Wednesday, 18/06/2008 11:20:41 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 39914	
Estimate Number : 10937	
P.O. Number :	Part Number : D29392
This Issue : 18/06/2008 S.O. No. :	Drawing Number : D2939 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 36144	Material :
Written By :	Due Date : 05/07/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JUL 08.06.18</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: 63437288 08/06/09

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Debur

(8)
DIP / 88 08/06/29

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

(8)
DIP 08/07/01

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

(8)
DIP 08/07/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 11:20:41 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 39914

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/07/02

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

mk 08/07/02

(8X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

2:30

OVEN TEMPERATURE:

320

FINISH TIME:

3:00

BR 08/07/02

(8X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/07/03

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/07/03

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/03

Job Completion



mk 08-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 39914	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.114	0.116	0.116	0.116	0.115
B	0.100	0.140		.116	0.112	0.114	0.114	0.114
C	0.100	0.140		0.115	0.114	0.1165	0.118	0.118
D	0.210	0.230		.220	.220	0.221	0.221	0.221
E	1.245	1.255		1.249	1.2495	1.2495	1.250	1.249
F	1.245	1.255		1.251	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.501	2.501	2.500
H	0.510	0.515		0.511	0.511	0.511	0.511	0.511
I	1.572	1.582		1.577	1.577	1.576	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	0.259	0.259	0.259
L	0.312	0.317		0.316	0.316	0.316	0.316	0.316
M	0.235	0.240		0.240	0.240	0.239	0.238	0.238
N	0.100	0.140		.121	.121	0.121	0.121	0.121
O	0.540	0.560		.550	0.5525	0.554	0.554	0.554
P	0.490	0.510		0.490	0.500	0.500	0.499	0.499
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.750	2.750	2.750	2.749	2.750
S	0.240	0.270		.250	0.247	0.247	0.248	0.248
T	0.100	0.180		.131	0.135	0.135	0.135	0.135
U	1.625	1.635		1.630	1.630	1.630	1.629	1.630
V	1.362	1.372		1.370	1.370	1.368	1.367	1.368
W	0.316	0.321		.321	.321	0.321	0.321	0.321
X	1.250	1.270		1.260	1.260	1.260	1.260	1.260
Y	1.565	1.585		1.575	1.577	1.577	1.576	1.577
Z	0.178	0.198		.184	.184	0.188	0.188	0.188
AA								
AB								
AC								
AD								

Accept/Reject

Measured by: SD 08/06/09 / DDA 08/07/01	Date: 08/07/01
Audited by: [Signature]	Date: 08/07/02
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

DART AEROSPACE LTD		Work Order: 39914
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

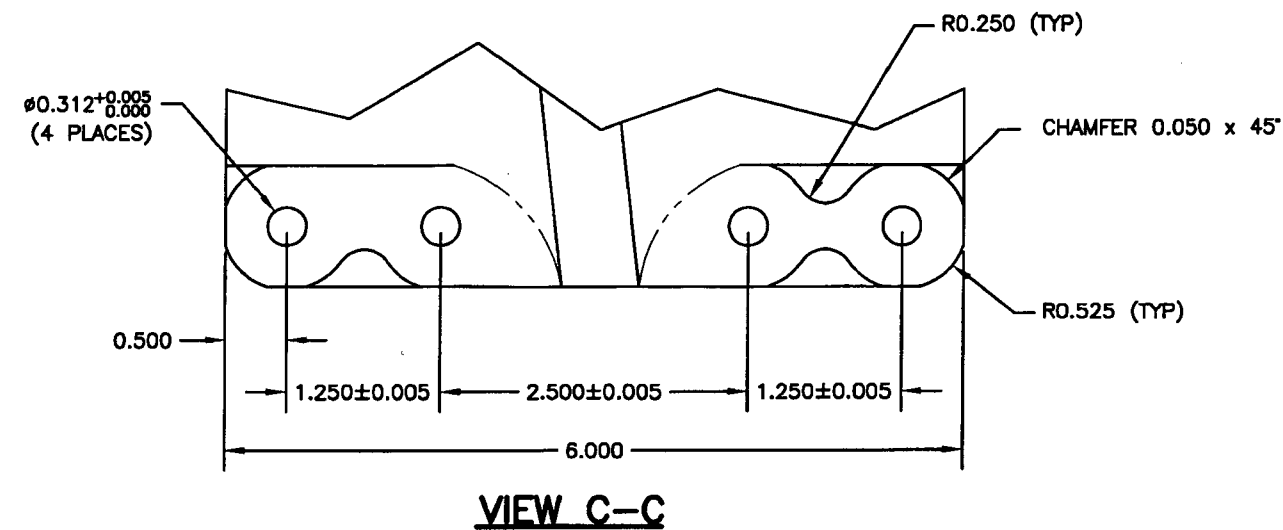
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	4	5
A	0.100	0.140		0.117	0.115	0.116		
B	0.100	0.140		0.114	0.114	0.114		
C	0.100	0.140		0.118	0.116	0.116		
D	0.210	0.230		0.221	0.221	0.221		
E	1.245	1.255		1.249	1.249	1.250		
F	1.245	1.255		1.250	1.251	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511		
I	1.572	1.582		1.577	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259		
L	0.312	0.317		0.316	0.316	0.316		
M	0.235	0.240		0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.121		
O	0.540	0.560		0.554	0.555	0.555		
P	0.490	0.510		0.501	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.720	2.760		2.747	2.748	2.748		
S	0.240	0.270		0.248	0.248	0.248		
T	0.100	0.180		0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321	⊖	0.321	0.321	0.321		
X	1.250	1.270		1.2605	1.605	1.2605		
Y	1.565	1.585		1.577	1.577	1.577		
Z	0.178	0.198	⊖	0.188	0.188	0.188		
AA								
AB								
AC								
AD								
Accept/Reject								

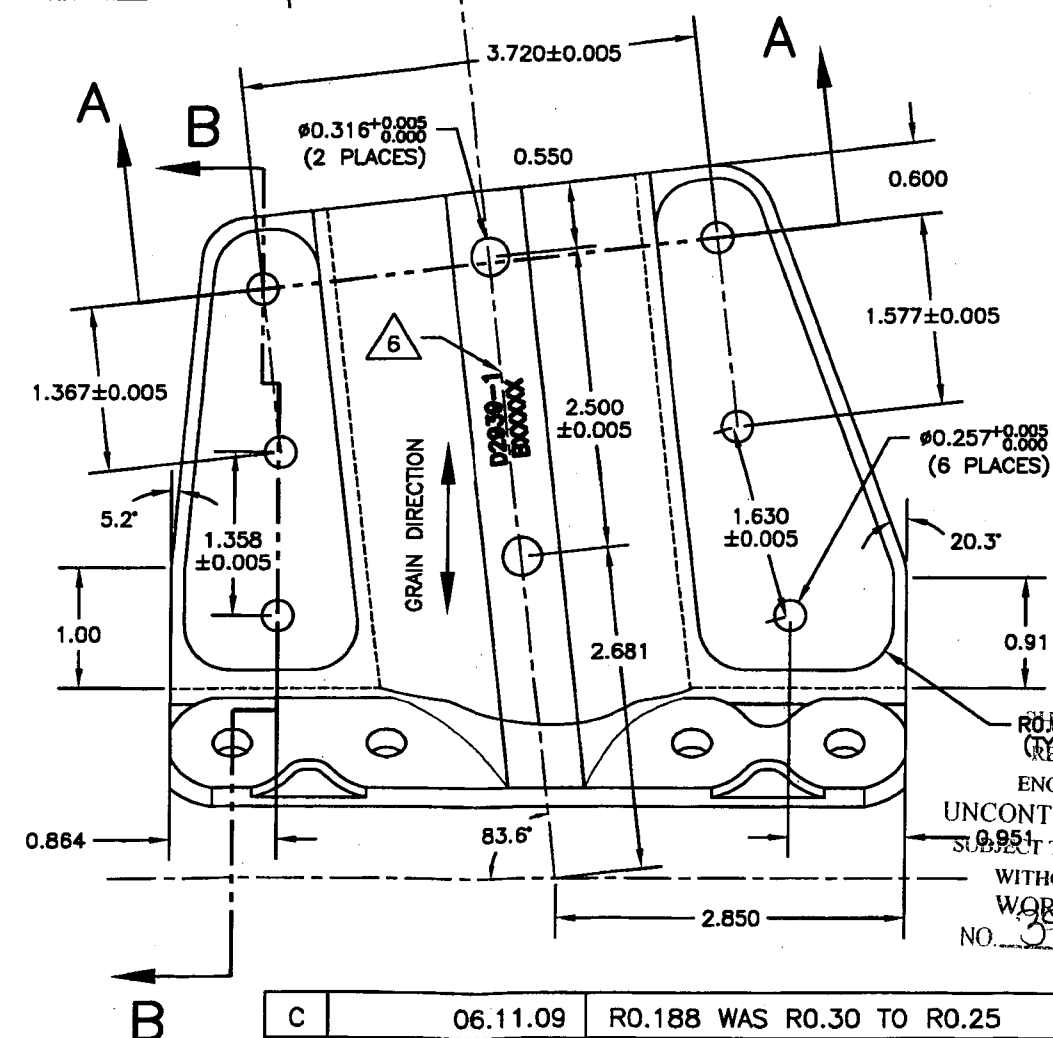
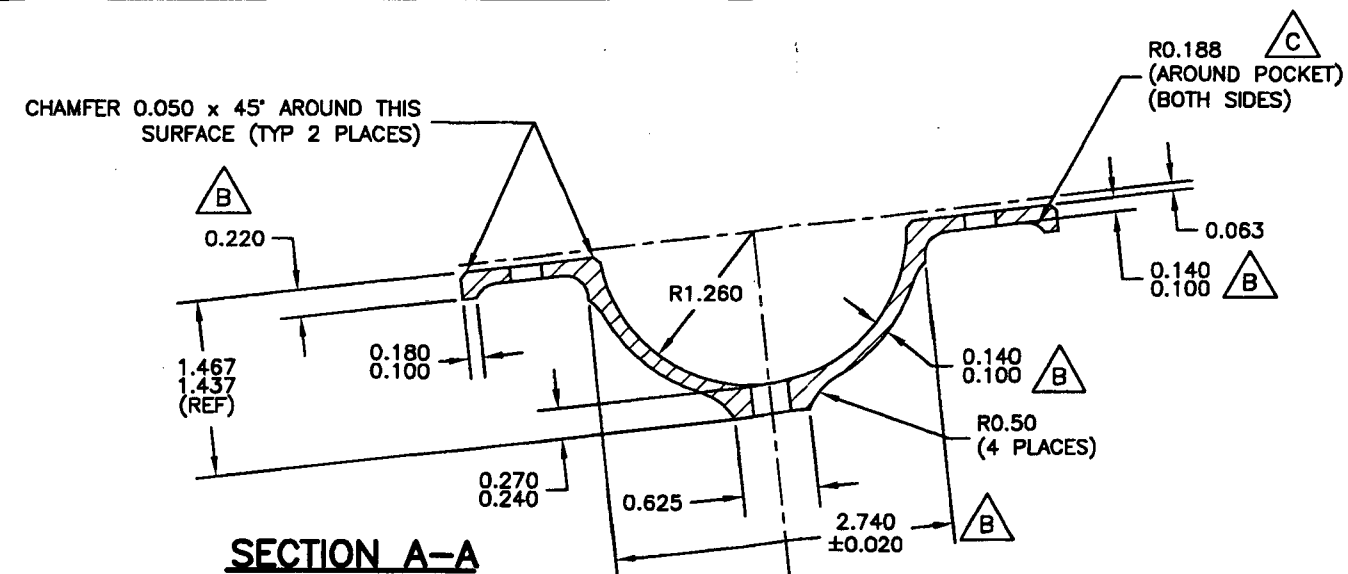
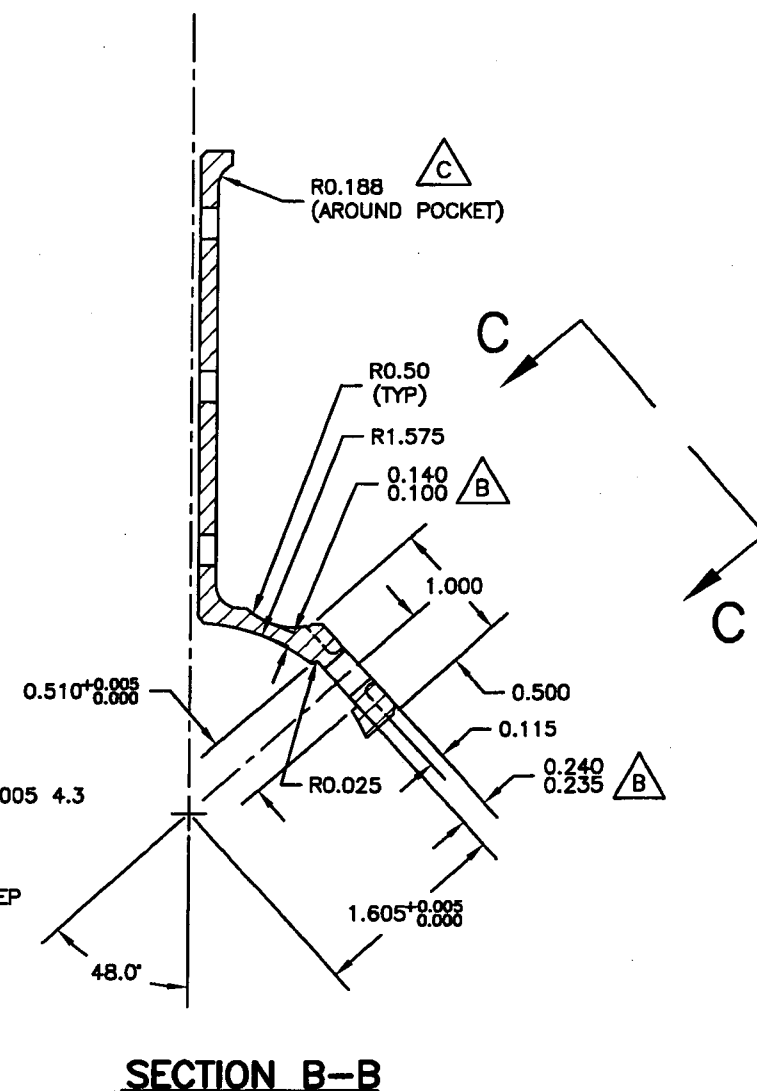
Measured by: DAP	Date: 08/07/01
Audited by: MK	Date: 08/07/02
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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 WITHOUT NOTICE
 WORK ORDER
 NO. 3917

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		SCALE 2:3
		DRAWING NO. D2939
		REV. C SHEET 1 OF 1

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 BELLEVUE, WA